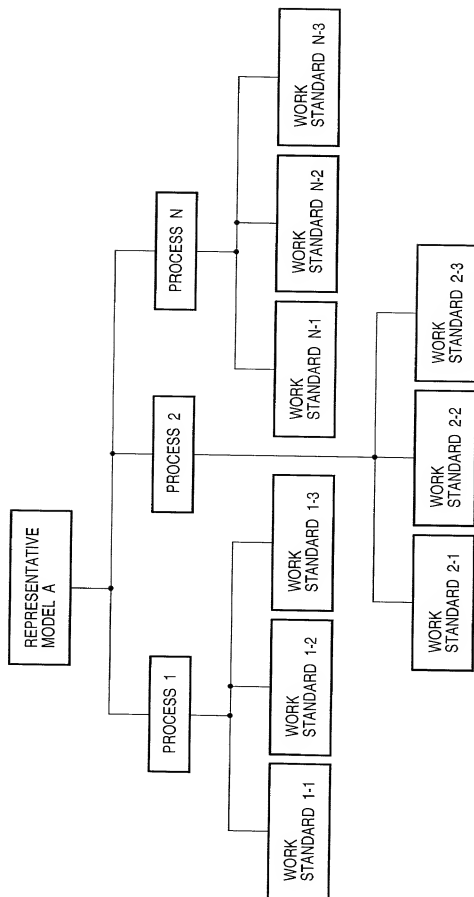


FIG. 1

FIG. 2



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FIG. 3

WORK STANDARD 01 CREATION				302		300	
APPLIED							
PART NUMBER	PART NAME	QUANTITY	PART NUMBER	PART NAME	QUANTITY		
303	304	305					
TOOL / TREATMENT DEVICE / AUXILIARY MATERIAL				QUANTITY	CHECK ETC.		
		306		307	308		
No.	WORK PROCEDURE	No.	NOTE / STANDARD ETC.				
	310						
REVISION NUMBER CONTENTS OF REVISION				DATE	PERSON IN CHARGE	APPROVE	WORK NAME
01	CREATED	1997/09/25					
						MANAGEMENT NO.	

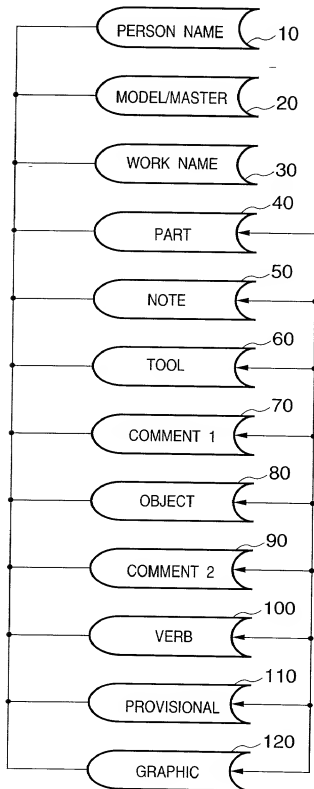
301

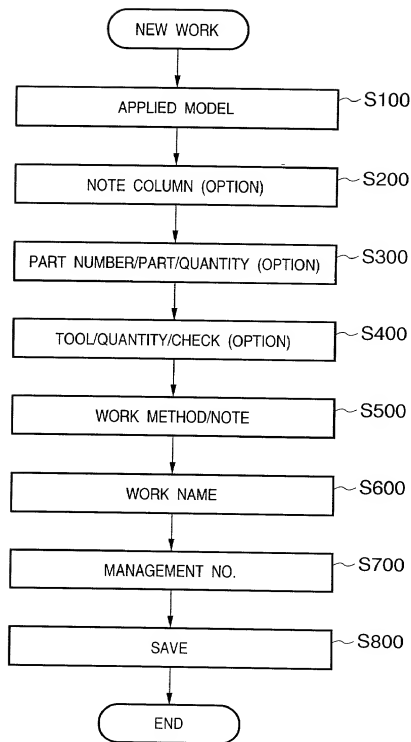
309

311

**FIG. 4**

STRUCTURE OF MASTER FILE



**FIG. 5**

**FIG. 6**

SELECTION OF APPLIED MODEL
LIST OF APPLIED MODELS
BJC-4200 SYSTEM
BJC-420J
BJC-420J (BLACK)
BJC-4300
BJC-430J
BJC-4200LX
A250 II Q
BJC-4200
OK
CANCEL

FIG. 7

WORK STANDARD 01 CREATION					<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
APPLIED		BJC-420J BJC-420J(BLACK) BJC-430J				
PART NUMBER	PART NAME	QUANTITY	PART NUMBER	PART NAME	QUANTITY	
<div style="text-align: right;">302</div>						

**FIG. 8**

PART NUMBER	PART NAME	QUANTITY	PART NUMBER
PART			
000 - 0000 - 001	PART 001	▲	
000 - 0000 - 002	PART 002		
000 - 0000 - 003	PART 003		
001 - 0000 - 001	PART 101	▼	
001 - 0000 - 002	PART 102		
111 - 1111 - 001	PART 001		
A01 - 1234 - 001	TEST PART 0001		



**FIG. 9**

- WORK NAME
- CANDIDATES
  - (SET ORIGINAL GLASS PROTECTIVE SHEET)
  - (HOOK DEVELOPING RAIL RETURN SPRING)
  - (HOOK DEVELOPING RAIL RETURN SPRING(AFTER))
  - (SET ORIGINAL GLASS TABLE)
  - (SET ORIGINAL TABLE PROTECTIVE SHEET)
  - (CHECK NO TONER IN DEVELOPER)
  - (CHECK ERROR IN DEVELOPER)
  - (LOCK DEVELOPER)

**FIG. 10**

• WORK NAME

• CANDIDATES

(HOOK DEVELOPING RAIL RETURN SPRING)

(HOOK DEVELOPING RAIL RETURN SPRING(AFTER))

(CHECK NO TONER IN DEVELOPER)

(CHECK ERROR IN DEVELOPER)

(LOCK DEVELOPER)

FIG. 11

1100

WORK STANDARD SYSTEM

WORK NAME :

WORK METHOD :

1101 (COMMENT 1)

1102 (OBJECT)

1103 (COMMENT 2)

1104 (VERB)

00 ※ 1105a

01 1105b

NOTE, STANDARD / REQUIRED QUALITY :

1106

1107

OK 1108

CANCEL

FIG. 12

WORK STANDARD SYSTEM

WORK NAME :

WORK METHOD :

1201

1202

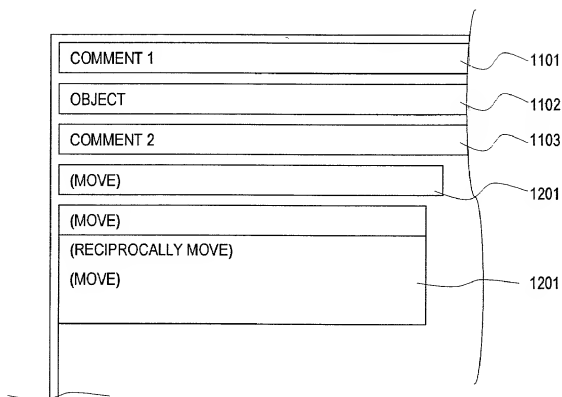
00 ※

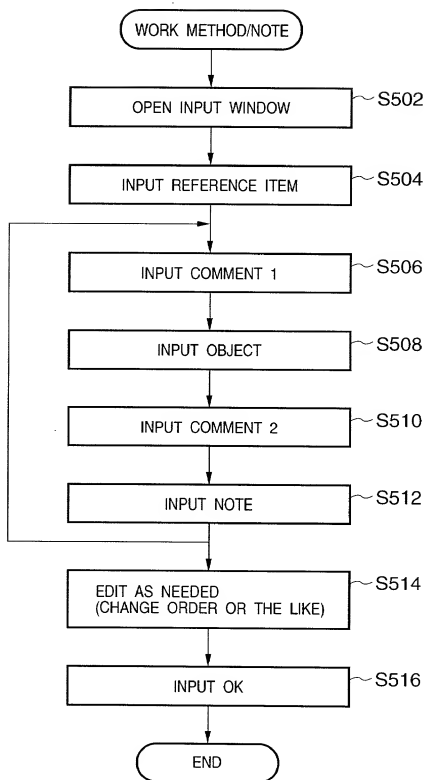
01

1105b

The diagram shows a rectangular frame representing a system interface. At the top is a header bar labeled 'WORK STANDARD SYSTEM'. Below it are two labels, 'WORK NAME :' and 'WORK METHOD :'. Under 'WORK NAME :' is a single-line input field labeled '1201'. Under 'WORK METHOD :' is a multi-line input area labeled '1202'. At the bottom is a section labeled '1105b' containing two rows: the first row has the text '00 ※' and the second row has the text '01'.

FIG. 13



**FIG. 14**

**FIG. 15**

00	※	
01	DO zzzz SUCH THAT xxxx AT wwww POSITION BECOMES yyyy	
02	WIND AV CORD	
03	CONFIRM 100V SYSTEM	
04	SET CRG HOLDER	

**FIG. 16**

NOTE, STANDARD / REQUIRED QUALITY	1601
NOTE	
<p>SEPARATION GRIPPER MOVES SLOWLY WITHOUT GRIPPER SPRING OF ASF<sub>u</sub></p> <p>DON'T PULL TAPE TOO STRONG TO MAKE SIDE GUIDE LOOSE</p> <p>DON'T HOOK PAPER GUIDE u ON SHEET HOLDER</p> <p>BEWARE OF IMITATIONS</p> <p>BEWARE OF IMITATIONS(Color Style Write</p>	1602

09753726.1015001



**FIG. 17**

NOTE, STANDARD / REQUIRED QUALITY	
1	NOTE

1107

FIG. 18

CONFIRM	
00 ※	
01 CONFIRM 100V SYSTEM	CUT(I)
02 WIND AV CORD	COPY(C)
03 SET CRG HOLDER	PASTE(P)
04	ADD(A)
	DELETE(D)
	UNDO
	REVISE(CHANGE)
	REVISE(DELETE)
NOTE, STANDARD / REQUIRED QUALITY	

1802

**FIG. 19**

CONFIRM	
00	※
01	WIND AV CORD
02	CONFIRM 100V SYSTEM
03	SET CRG HOLDER
04	

NOTE, STANDARD / REQUIRED QUALITY

FIG. 20

The diagram shows a menu structure. A main menu on the left contains the following items:

- CONFIRM
- 00 ※
- 01 WIND AV CORD
- 02 SET CRG HOLDER
- 03
- NOTE, STANDARD / REQUIRED QUALITY

A context menu, labeled 1802, is open next to the '03' item. It contains the following options:

- CUT(I)
- COPY(C)
- PASTE(P) (highlighted with a thick border)
- ADD(A)
- DELETE(D)
- UNDO
- REVISE(CHANGE)
- REVISE(DELETE)

FIG. 21

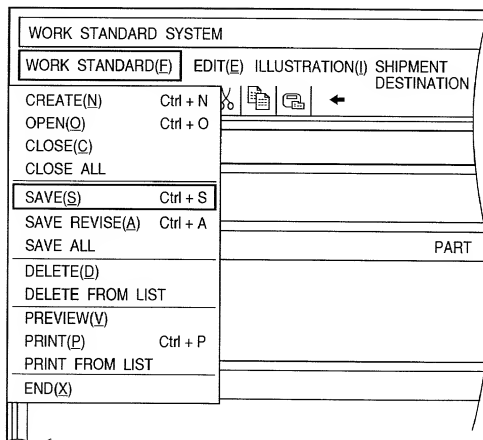




FIG. 22

WORK STANDARD SYSTEM	
WORK STANDARD(E)	EDIT(E) ILLUSTRATION(I)
CREATE(N) Ctrl + N	X %         ←
OPEN(O) Ctrl + O	
CLOSE(C)	
CLOSE ALL	
SAVE(S) Ctrl + S	
SAVE REVISE(A) Ctrl + A	
SAVE ALL	
DELETE(D)	
DELETE FROM LIST	
PREVIEW(V)	
PRINT(P) Ctrl + P	
PRINT FROM LIST	
END(X)	

23/97

FIG. 23

WORK STANDARD SYSTEM			
<input checked="" type="radio"/> LATEST REVISION NUMBER <input type="radio"/> ALL			
MANAGEMENT NO.	REVISION NUMBER	WORK NAME	DATE OF REGISTRATION
SO - 04 - 01(4) - E	01	SET ASFu	1997/09/13
SO - 01 - 01(3) - E	01	SET BASE TRAY	1997/09/01
SO - 01 - 03 - E	01	SET BASE TRAY	1997/09/01
SO - 01 - 04 - E	01	SET BASE TRAY	1997/09/01
SO - 06 - 01 - E	01	WIRING	1997/09/01
SO - 06 - 02 - E	01	WIRING	1997/09/01
SO - 06 - 03 - E	01	WIRING	1997/09/01
SO - 07 - 01(2) - E	01	GREASING	1997/09/01
SO - 08 - 01 - E	01	SET RAIL	1997/09/01

2301

FIG. 24



SYSTEM		
EDIT(E)	ILLUSTRATION(I)	SHIPMENT DESTINATION(S)
		VIEW(V)
		EDIT(E)
01 CREATE		PowerPoint
		✓ Canvas



FIG. 25

WORK STANDARD 01 CREATION

APPLIED

PART NUMBER

PART NAME

303

TOOL / TREATMENT DEVICE

No.

WORK PROCEDURE

FILE NAME :

2501

2502

2503

2504

UPDATE

CLEAR

CLOSE

2500

REVISION NUMBER

01

CONTENTS OF REVISION

CREATED

1997/09/25

DATE

PERSON IN CHARGE

APPROVE

WORK NAME

MANAGEMENT NO.

FIG. 26

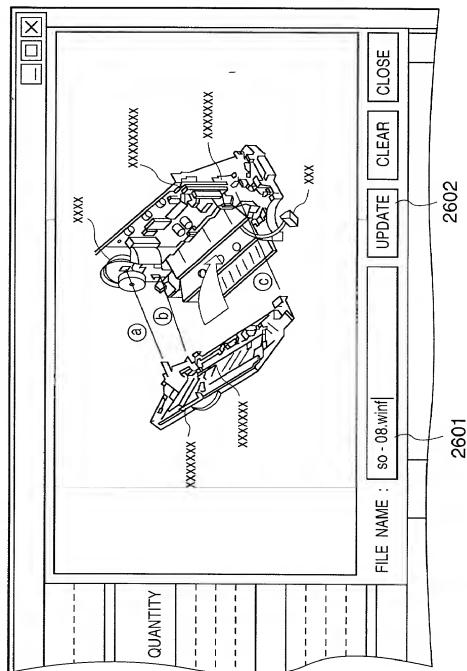


FIG. 27

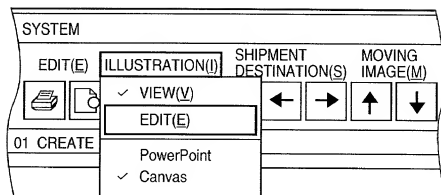
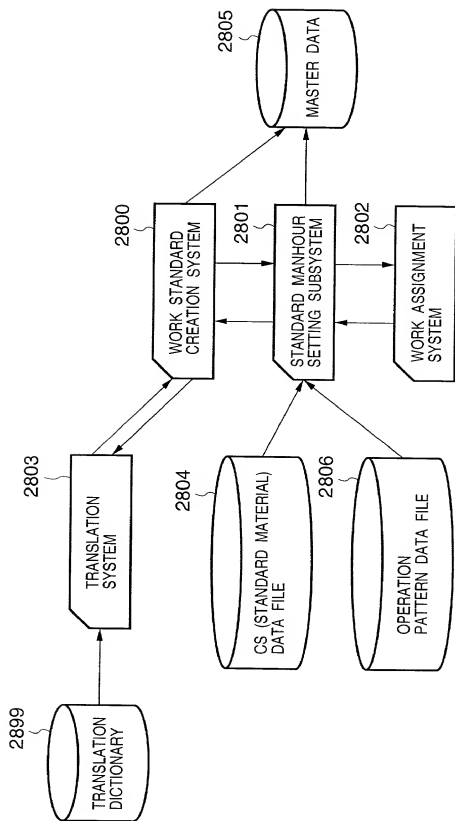


FIG. 28



**FIG. 29**

WORK STANDARD : TRANSLATION SYSTEM (PROTOTYPE) [X]

☒ WORK STANDARD DATA  
☐ MASTER DATA

UPLOAD WORK STANDARD

DOWNLOAD WORK STANDARD

TRANSLATE WORK STANDARD

END

FIG. 30

3001 3002 3003 3004

TRANSLATION OF WORK STANDARD

REPRESENTATIVE MODEL NAME : A252

PREPUCES NAME : PLATEN UNIT

TOTAL UNIT  
ASSEMBLY

DISPLAY DATA  
☒ ALL  
☐ UNTRANSLATED  
☐ UNCHECKED

DISPLAY LANGUAGE  
☐ JAPANESE  
☒ ENGLISH

3000

MANAGEMENT NO.	REVISION NUMBER	WORK NAME	AUTOMATIC TRANSLATION	CHECK
PT - 010 - 010	01	SET CLEANER UP	X	X
PT - 010 - 020	01	SET CLEANER UP	X	X
PT - 010 - 030	01	SET CLEANER UP	X	X
PT - 070 - 030	01	ASSEMBLE CHANGE OVER ARM	X	X
PT - 080 - 010	01	SET TRANSMISSION ROLLER	X	X
PT - 090 - 010	01	SET TRANSMISSION ROLLER	X	X
PT - 100 - 010	01	SET SHEET HOLDER	X	X

3006

3007

3008

3005

SELECT ALL CANCEL SELECT VIEW TRANSLATE TRANSLATE ALL CLOSE

**FIG. 31**

3101-

FIG. 32

WORK PROCEDURE

VOICE(W)

JAPANESE

WORK PROCEDURE

ブレードレバーをブレードレバーの ① 部に引っ掛ける

01 ブレードレバーをブレードレバーの ① 部に引っ掛ける

02 ブレードレバーを矢印 ② 方向にスライドさせ引っ掛かり無くバネ力で戻ることを確認する

03 ブレードレバー軸先端がブレードレバー先端まで圧入されていることを確認する

ENGLISH

Procedure

The blade lever spring hooks to ① of the blade lever.

01 The blade lever spring hooks to ① of the blade lever.

02 Side the blade lever in the direction of arrow ② and there is no catch and n....

03 Check press-fitting the blade lever shaft leading edge to the braid folder leading ed....

TRANSLATE OK CANCEL



FIG. 33

TRANSLATION OF WORK STANDARD (PROTOTYPE)		<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
WORK STANDARD(E) ILLUSTRATION(I)		VOICE(S) DOWN(W)	
WORK STANDARD PN-030-020 01 Net		PLAY(P) X2056) A252 PLATEN UNIT	
Model QG5-1317		NEW(N) DRIVE(D)	
<div style="border: 1px solid black; height: 20px; width: 100%;"></div>		<div style="border: 1px solid black; height: 20px; width: 100%;"></div>	

FIG. 34

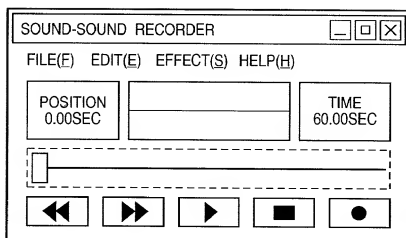


FIG. 35

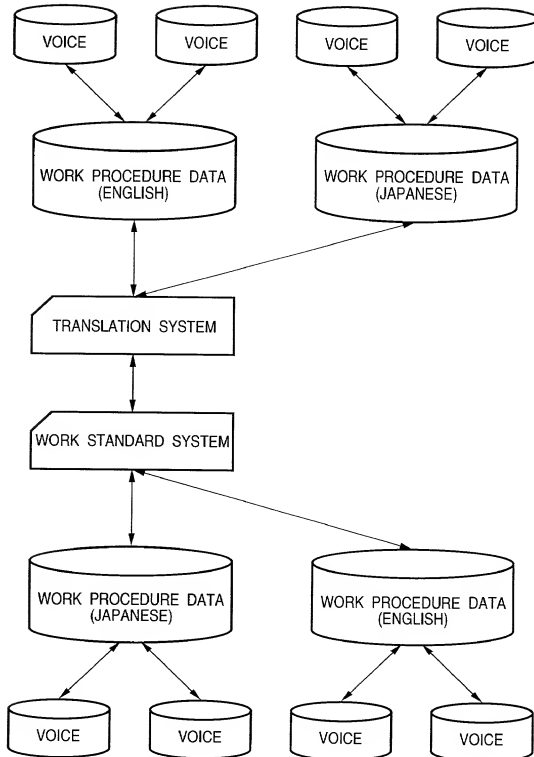


FIG. 36

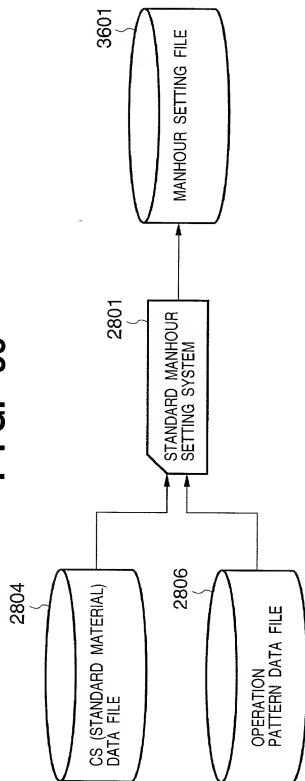


FIG. 37

No.	ELEMENT WORK NAME	FREQUENCY	MANHOUR	CS	SET CONDITION

**FIG. 38**

STANDARD MATERIAL DATA

COMMENT 1	OBJECT	COMMENT 2	VERB	SET CONDITION DATA

**FIG. 39**

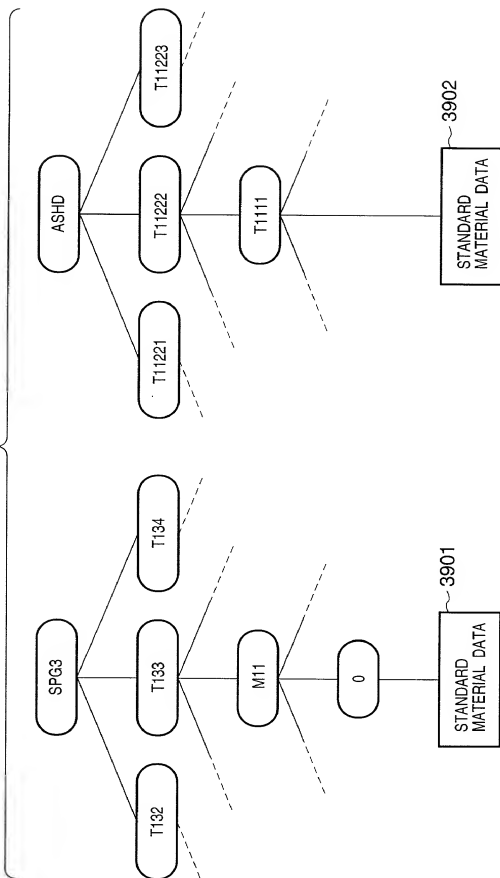


FIG. 40

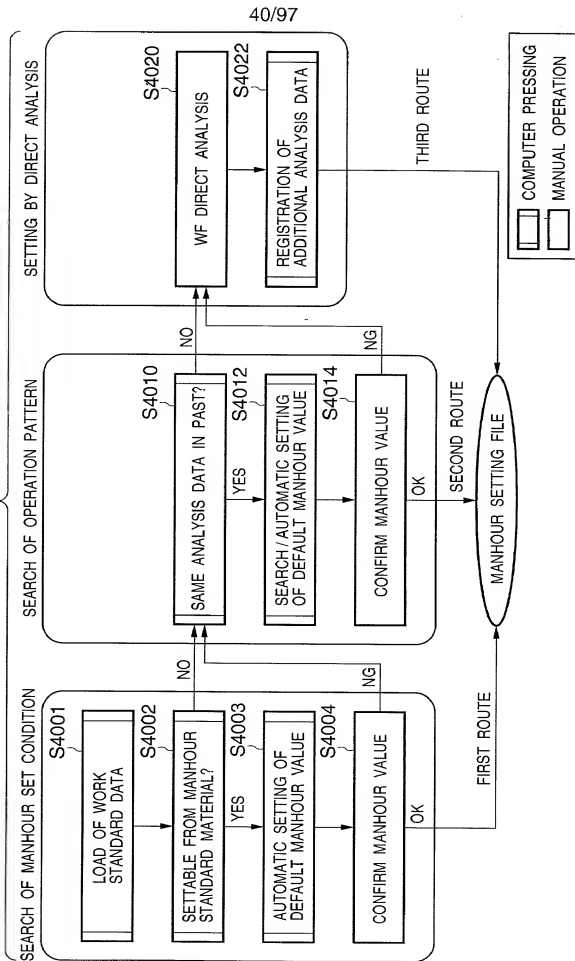




FIG. 41

3601

[illegible]

• ELEMENT WORK NAME



## DATA LOAD

No	COMMENT 1	OBJECT	COMMENT 2	VERB
1		LOAD SPRING	IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING	SET
2	OF TREATMENT DEVICE	SW		TURN ON
3		SEPARATION ROLLER	IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING	SET
4	OF TREATMENT DEVICE	SW		TURN OFF
5		SEPARATION ROLLER	FROM TREATMENT DEVICE	DETACH

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## FIG. 42

3601

EDITING OF ELEMENT WORK						
FILE(F) EDIT(E) VIEW(V) ANALYZE(A) ANALYSIS MATERIAL(B) CS(S) END(X)						
UNIT WORK NAME : SEPARATION ROLLER ATTACHMENT						
No.	ELEMENT WORK NAME	FREQUENCY		MANHOUR	CS	SET CONDITION
1	(SET LOAD SPRING IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1	41	SPG3	T133 / M11 / 0
2	(TURN ON SW OF TREATMENT DEVICE)	1	1	8		
3	(SET SEPARATION ROLLER SHAFT IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1	37	ASHD	T11222 / T1111
4	(TURN OFF SW OF TREATMENT DEVICE)	1	1	8		
5	(DETACH SEPARATION ROLLER SHAFT FROM TREATMENT DEVICE)	1	1	16	PUMB	T2111 / T111111

MATCH

SEARCH KEYWORD (KW)

No.	COMMENT 1	OBJECT	COMMENT 2	VERB	MANHOUR STANDARD MATERIAL	TIME VALUE
1	*	SPRING	TO *	SET	SPG3 T133/M11/0	41RU
2	*	*	TO *	SET	ASHED T11222/T1111	37RU
3	*	*	FROM *	DETACH	PUMQ T2111/T111111	16RU
4	*	E-RING	*	SET	RIN2 T11211/SO	76RU
5	*	CONNECTOR	*	INSERT	CONN T11211/SO	41RU
6	*	*	*	SCREW TIGHTLY	SCR6 M211/1	23RU

2804

[illegible]

No	COMMENT 1	OBJECT	COMMENT 2	VERB	VERB PATTERN	TIME VALUE
1	TREATMENT DEVICE	SW		TURN ON	/GET -50E/M -10E	8RU
2	TREATMENT DEVICE	SW		TURN OFF	/GET -50E/M -10E	8RU
3		READING OPERATION UNIT		CLOSE	/GET -50E/M -50E	10RU
4		CRG DOOR		CLOSE	/GET -50E/M -50E	10RU
5		READING OPERATION UNIT		CLOSE	/GET -50E/M -50E	10RU
6		POWER CODE		PULL OUT	/GET -50Egr2/M -10E	16RU
7		POWER CODE FOR MEASUREMENT		PULL OUT	/GET -50Egr2/M -10E	16RU

FIG. 44

3601

[illegible]

FIG. 45

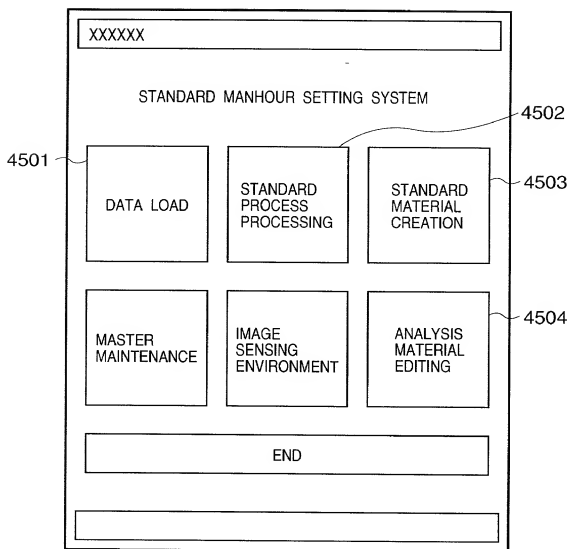


FIG. 46

4609 4610

XXXXXXX

☒ ALL ☐ DESIGNATE :

PRODUCT NUMBER :

NAME :

OK

4612

PRODUCT NUMBER	WORK STANDARD	PRODUCT SYMBOL	NAME	PREVIOUS LOAD DATE
0 - CLOCK	XXXX	XX	XXXX	XXX
XXXXXX		BL - OLD	SET IN 1996	
XYZ - test				
test - 01				
tesr - AMI				

4601

4602 4603 4604 4605

SELECT

CANCEL

4611

**FIG. 47**

[illegible]

FIG. 48

LOAD OF DATA

COMPONENT DESIGNATION

☐ ALL

☒ DESIGNATE COMPONENT

CH

AUTOMATIC MANHOUR SETTING

☒ STANDARD MATERIAL(CS)

☒ ANALYSIS MATERIAL

EXECUTE

CANCEL

4800

4801

4802

4803

4804

4805

4806



**FIG. 49**

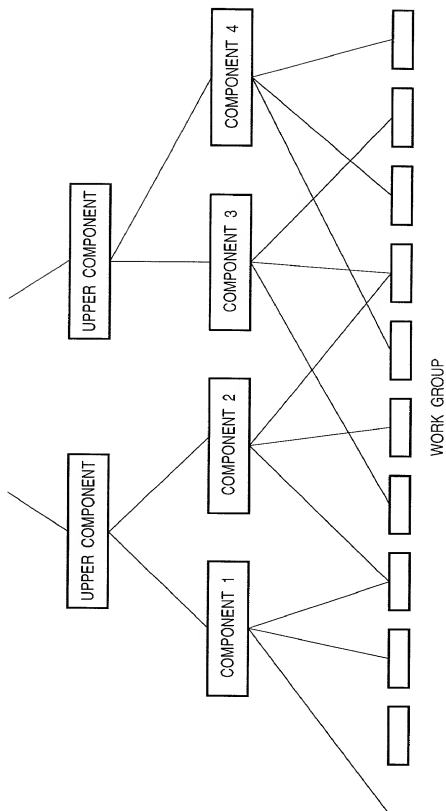
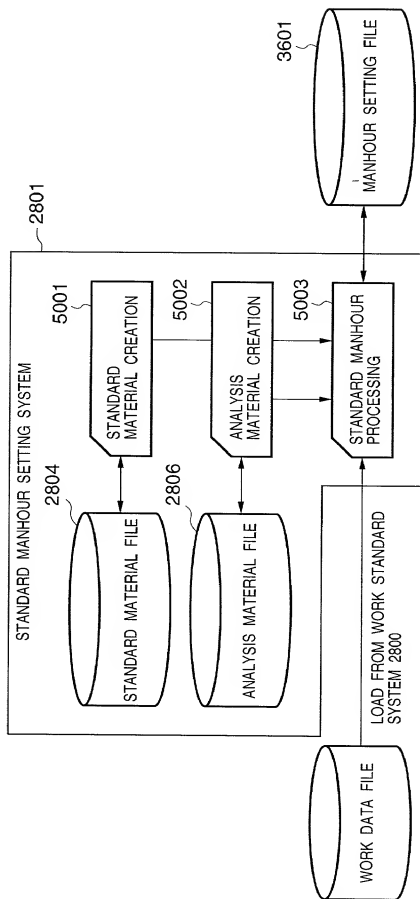
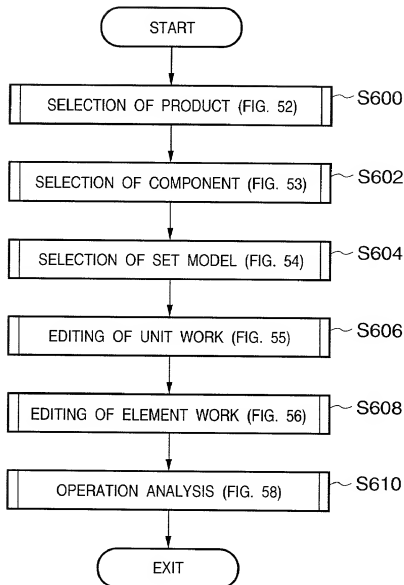


FIG. 50



**FIG. 51**

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FIG. 52

SELECTION OF PRODUCT		FILE(F) EDIT(E)																							
<table border="1"> <thead> <tr> <th>PRODUCT SYMBOL</th> <th>NAME</th> <th>PREVIOUS UPDATE DATE</th> </tr> </thead> <tbody> <tr> <td>BJ - 970909</td> <td>XXXX</td> <td>1997/09/22 10:17:30</td> </tr> <tr> <td>BJ - STAND</td> <td></td> <td>1997/09/12 15:09:09</td> </tr> <tr> <td>BJ - test</td> <td>TEST 01 Standard</td> <td>1997/09/18 10:38:14</td> </tr> <tr> <td>BJ/250</td> <td>250 TESTS</td> <td>1997/09/17 17:58:59</td> </tr> <tr> <td>ST01</td> <td>STAND PRODUCT</td> <td>1997/09/12 16:02:34</td> </tr> <tr> <td>STAND01</td> <td></td> <td>1997/09/19 15:46:04</td> </tr> </tbody> </table>		PRODUCT SYMBOL	NAME	PREVIOUS UPDATE DATE	BJ - 970909	XXXX	1997/09/22 10:17:30	BJ - STAND		1997/09/12 15:09:09	BJ - test	TEST 01 Standard	1997/09/18 10:38:14	BJ/250	250 TESTS	1997/09/17 17:58:59	ST01	STAND PRODUCT	1997/09/12 16:02:34	STAND01		1997/09/19 15:46:04			
PRODUCT SYMBOL	NAME	PREVIOUS UPDATE DATE																							
BJ - 970909	XXXX	1997/09/22 10:17:30																							
BJ - STAND		1997/09/12 15:09:09																							
BJ - test	TEST 01 Standard	1997/09/18 10:38:14																							
BJ/250	250 TESTS	1997/09/17 17:58:59																							
ST01	STAND PRODUCT	1997/09/12 16:02:34																							
STAND01		1997/09/19 15:46:04																							
SET MANHOURL <input type="text"/>		EXTRACT DATA <input type="text"/>		CREATE HOST TRANSFER <input type="text"/>																					
		ANALYZE DATA		END																					

5201

FIG. 53

SELECTION OF COMPONENT			
FILE(E) EDIT(E)			
PRODUCT SYMBOL : BJ - 4200		NAME : BJ - 4200	
COMPONENT SYMBOL	NAME	PREVIOUS UPDATE DATE	
▲ BK	XXXXX	1997/09/22 11:09:59	
CH	CHECK PROCESS	1997/09/12 11:09:59	
KO	PACKAGE	1997/09/18 11:21:07	
NEXT		DOWNLOAD	UPLOAD
BACK UP		LIST	CANCEL ACCESS FLAG
END			

FIG. 54

SELECTION OF MODEL			
FILE(F) EDIT(E) VIEW(V)			
PRODUCT NUMBER : BJ - 970909      NAME : 97 - 09 - 09 LOAD COMPONENT SYMBOL : CH      NAME :			
SET MODEL SYMBOL	QUANTITY	NAME	PREVIOUS PUBLICATION DATE
▲ A250 IIQ			
BJC - 4200LX			
BJC - 4200 SYSTEM			
BJC - 420J			
BJC - 420J(BLACK)			
BJC - 4300		XXXXXX	1997/09/09 10:46:33
BJC - 430J			

FIG. 55

SELECTION OF MODEL									
FILE(E) EDIT(E) VIEW(V)									
<div> </div>									
PRODUCT SYMBOL : BJ - 970909					NAME : 097 - 09 - 09 LOAD SET MODEL SYMBOL : BJC - 4300				
COMPONENT SYMBOL : ON					NAME : xxxxx				
					LATEST REVISION NUMBER		UPDATE DISPLAY		
S	FORMAL MANAGEMENT NO.	REVISION	UNIT WORK NAME	MAN-HOUR	USE	CS	FREQUENCY		
N <sup>1</sup> 3	CH-01-01	1	ELECTRIC CHECKING	0	0	0	0	1	
N <sup>1</sup> 4	CH-01-02(1)	1	ELECTRIC CHECKING	0	0	0	0	1	
N <sup>1</sup> 5	CH-01-02(2)	1	ELECTRIC CHECKING	0	0	0	0	1	
N <sup>1</sup> 6	CH-01-03	1	ELECTRIC CHECKING	0	0	0	0	1	
N <sup>1</sup> 7	CH-01-04	1	ELECTRIC CHECKING	0	0	0	0	1	
N <sup>1</sup> 23	CH-07-02(1)	1	SET FRONT COVER	0	0	0	0	1	
N <sup>1</sup> 24	CH-07-02(2)	1	SET FRONT COVER	0	0	0	0	1	
N <sup>1</sup> 25	CH-07-01(3)	1	SET FRONT COVER	0	0	0	0	1	
N <sup>1</sup> 26	CH-07-01(4)	1	SET FRONT COVER	0	0	0	0	1	
No.	FORMAL MANAGEMENT NO.	UNIT WORK NAME		MAN-HOUR	USE	FREQUENCY			
3	CH-01-01	ELECTRICAL CHECK		0	0	1	2	3	4 5
<div> <input type="radio"/> CHANGE           <input type="radio"/> INSERT           <input type="radio"/> ADD         </div> <div>OK</div>									

5501 5507 5506 5502 5503 5504 5505

FIG. 56

XXXXXX

FORMAL MANAGEMENT NO. PU-03-01      UNIT WORK NAME : MOTOR ATTACHMENT      TOTAL MANHOURL: 0      NEXT UNIT WORK

NO.	ELEMENT WORK NAME	REVISION	MANHOURL	US	CS	SET CONDITION
1	SET DOUBLE GEAR TO OPPOSITE SIDE OF AXIS IN ORDER OF SMALL GEAR DIAMETER	1	0	0	0	
*						

COMMENT 1 : TO OPPOSITE SIDE OF AXIS

OBJECT : DOUBLE GEAR

COMMENT 2 : IN ORDER OF SMALL GEAR DIAMETER

VERB : SET

5604      5605      5603      5602      5601



FIG. 57

EDITING OF ANALYSIS MATERIAL

FILE(E) EDIT(E) VIEW(V)

PRODUCT GENRE : ALL

TYPE/COMMENT 1	OBJECT	COMMENT 2	VERB	ANALYSIS SYMBOL	MAN/HR USE/FREQ.	COUNT	SET DATE
▶	AIR CAP: MAIN BODY	AS ARROW 1	INSERT	-50/Gr/IN>6/-3	15	0 1 1	0 97/09/09 9:52
	AIR CAP: MAIN BODY	AS ARROW 1	INSERT	-50/E/02/N/-6	11	0 1 1	0 97/09/09 9:53
	AIR CAP: MAIN BODY	AS ARROW 1	INSERT	-50/Gr/IN>6/-3	15	0 1 1	0 97/09/09 9:55
	ELEMENT WORK 01		VERB	-50/Gr/IN>6/-3	15	0 1 1	0 97/09/09 16:34
	AIR CAP: MAIN BODY	AS ARROW 1	INSERT	-50/Gr/IN>6/-3	15	0 1 1	0 97/09/09 19:09
	CARRIAGE LOCK		APPLY	Time100/Rate100	100	100 1 1	1 97/09/09 19:16
	ASSEMBLE MOTOR		INSERT & SET	M211/1/10	50	1 1 1	1 97/09/09 17:00
	PRINTER CHASSIS		TURN INSIDE OUT	T1221/M2311/0/0	12	0 1 1	0 97/09/09 17:34
	1		1	T2221/M1211/0/1	24	0 1 1	0 97/09/09 17:20
	2		2	T1221/M2311/0/0	12	0 1 1	0 97/09/09 17:24
	PRINTER CHASSIS	ASSEMBLE PR GUIDE	SET		15	0 1 1	0 97/09/09 11:24
	dgdfadfas		fdsafdsafdsaf	*	16	0 1 1	0 97/09/09 12:10
	asdfsfsdsaf		fdsafdsdfds	T2121/M1111/0/1	13	0 1 1	0 97/09/09 12:10
	dgdfadfas		fdsafdsafds	*	16	0 1 1	0 97/09/09 13:39
	PRINTER CHASSIS	ASSEMBLE PR GUIDE	SET		15	0 1 1	0 97/09/09 14:00
	PRINTER CHASSIS	ASSEMBLE PR GUIDE	SET		15	0 1 1	0 97/09/09 14:00
	PRINTER UNIT		SET	Time100/Rate100	100	100 1 1	0 97/09/09 14:04



FIG. 59

5901

<input type="radio"/> 1. PU	<input type="radio"/> 6. DSY	<input type="radio"/> 11. PU	<input type="radio"/> 16. DSY
<input type="radio"/> 2. GET	<input type="radio"/> 7. R	<input type="radio"/> 12. GET	<input type="radio"/> 17. R
<input type="radio"/> 3. M	<input type="radio"/> 8. UMAC	<input type="radio"/> 13. M	
<input type="radio"/> 4. MA	<input type="radio"/> 9. MP	<input type="radio"/> 14. MA	
<input type="radio"/> 5. ASY	<input type="radio"/> 10. BODY	<input type="radio"/> 15. ASY	

☐ SIMO

5902

FIG. 60

XXXXXX		PU		PICK UP		MANUAL	
1 :	MOVING DISTANCE	-10cm	1	+10cm	2	>50cm	3
2 :	GRIP TYPE	Qr-3		Qr-2			
3 :	PRE-POSITIONING	NO		YES			
4 :	MAIN SIZE	-10mm		-6mm			
5 :	WEIGHT	<3Kg		>3Kg			
6 :							

SET	CANCEL	SET VALUE	FORMULA
-----	--------	-----------	---------

6001      6002      6003

FIG. 61

FORMULA

TURN CHANGE DIRECTION OF BODY MANUAL

FORMULA : 10 \* m

VARIABLE

m :

n :

p :

q :

r :

s :

VARIABLE NAME

THE NUMBER OF TIMES OF OPERATION OF CHANGING DIRECTION

VALUE

UNIT

COUNT

6101

6104

6103

6102

6105

SET

CANCEL

SET VALUE

FIG. 62

INQUIRY OF LOG

VARIATION AMOUNT : 10

USE : 0

REASON CODE : 1

CHANGE REASON : SET ▼

OK Clear

6201 6202 6203 6204 6205 6206

FIG. 63

6301 6302

CORRECTION OF CHANGE LOG

DATE 1997 09 22 ○ = ○ FROM  
○ BEFORE ○ ~

SEARCH

NO.	UNIT WORK NAME	CHANGE REASON CODE	NEW MANHOUR	(NEW) MANUAL USE	(NEW) MANHOUR	(PREVIOUS) MANUAL	(PREVIOUS) USE	CHANGE DATE
▲ CH-01-01	ELECTRICAL CHECK	1	SET 10	10	0	0	0	1997/09/22 14:30.00

REASON CODE 1 CHANGE REASON SET

OK C/R END

FIG. 64

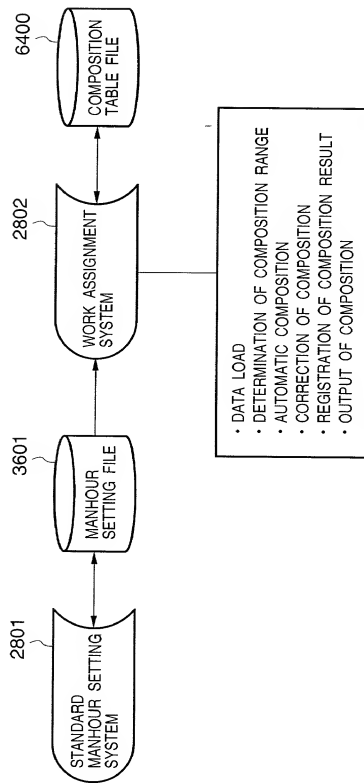




FIG. 65

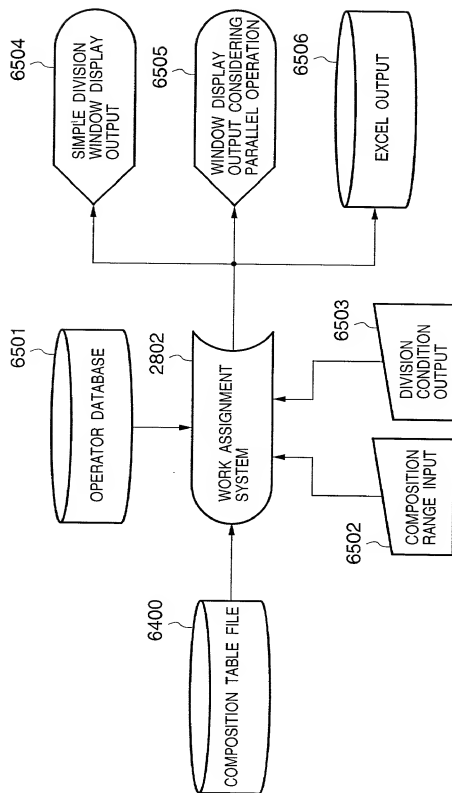


FIG. 66

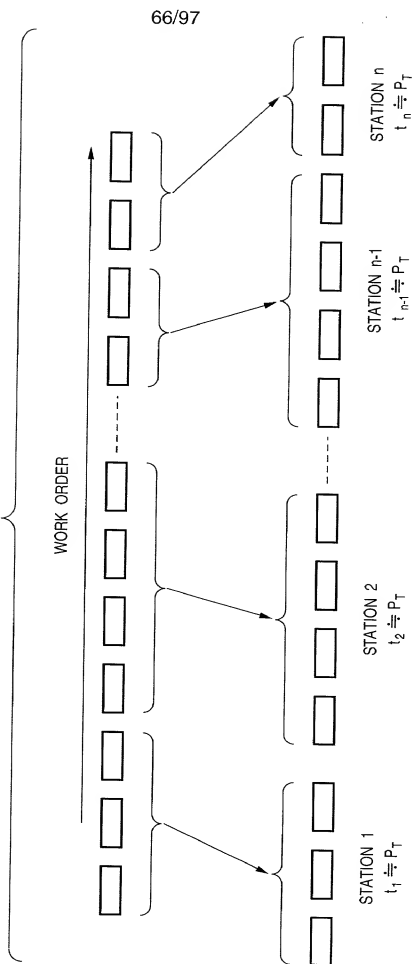


FIG. 67

	▶	▲
FILE(F) EDIT(E) INPUT(I) TOOL(O)		

MODEL

GP55

UNIT

STANDARD NO.	WORK NAME	MANHOUR
0001	STICK HANDY CUT TAPE	134
0002	SET LABELS ON MAIN BODY	550
0003	WEIMAN REMOVAL	270
0004	ASSEMBLE OUTER CASE	365
0005	FIT TOP PAD	288
0006	STICK LARGE-SIDE ORDER LABEL	117

⋮

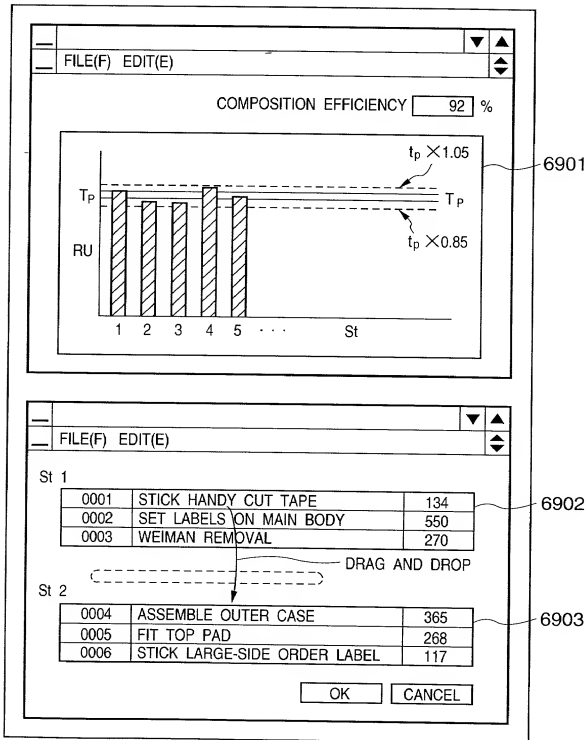
{
}
  
 SIMPLE DIVISION  
 PARALLEL DIVISION

FIG. 68

## SIMPLE DIVISION

		▼	▲
FILE(F) EDIT(E)		◆	
St 1			
0001	STICK HANDY CUT TAPE	134	
0002	SET LABELS ON MAIN BODY	550	
0003	WEIMAN REMOVAL	270	
St 2			
0004	ASSEMBLE OUTER CASE	365	
0005	FIT TOP PAD	268	
0006	STICK LARGE-SIDE ORDER LABEL	117	
⋮			

FIG. 69



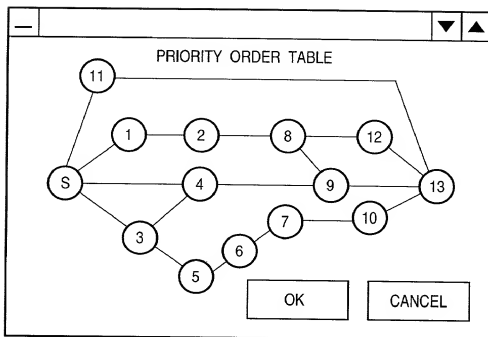
**FIG. 70**



FIG. 72

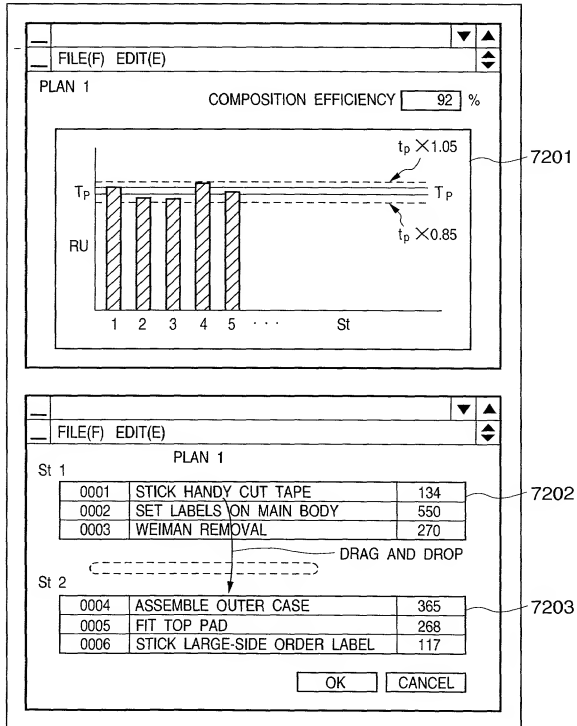




FIG. 73

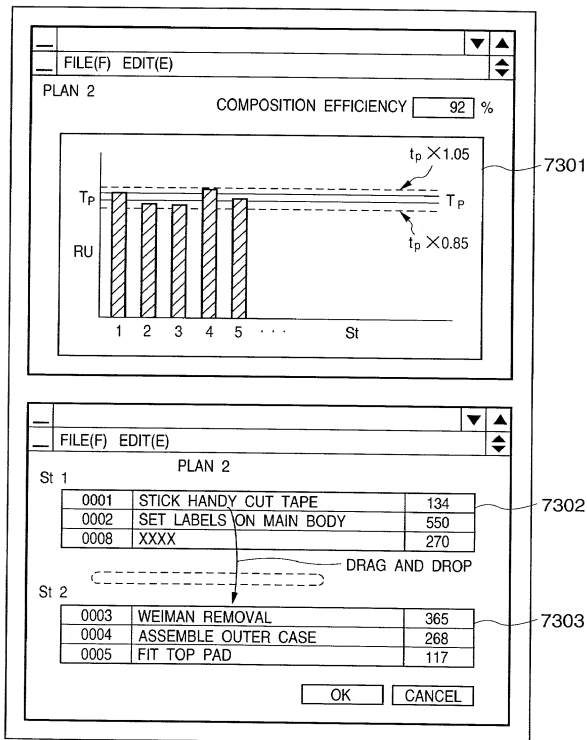


FIG. 74

74/97

LOAD OF NEWLY COMPOSED DATA (MANHOUR)

7401

7402

7403

7404

7405

7406

7407

7409

GENRE

REPRESENTATIVE MODEL

TARGET MODEL

COMPONENT

COMPONENT SYMBOL

COMPONENT NAME

ORDER

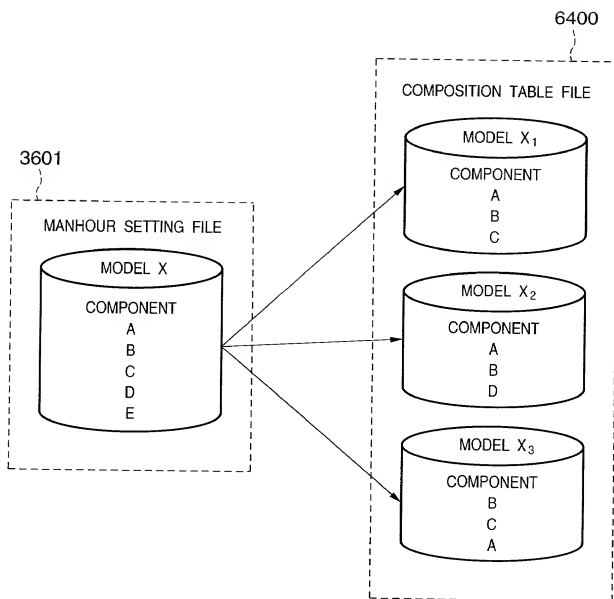
BJ  
FAX  
LBP  
NP  
STAND

OK

CANCEL

7408

FIG. 75



76/97

FIG. 76

7601

7602

7603

7604

OPEN FILE

TARGET MODEL

NAME

REVISION NUMBER

SAVE DATE

TEST DATA (ORIGINAL)	1	97/09/19 12:00:34
f12-0010.csv	0	97/09/19 13:27:17
f12-0010.csv	0	97/09/19 14:10:14
BJC-4300	0	97/09/19 14:10:32
BJC-4300	1	97/09/19 15:41:14
BJC-4300		97/09/20 14:16:58
BJC-4300	03	97/10/13 17:54:57
BJC-4300	00	97/09/20 14:06:36
f12-0010A.csv	05	97/09/24 17:11:53

SELECT WINDOW

☐ COMPOSITION DATA INPUT WINDOW

☐ COMPOSITOR DATA CORRECTION WINDOW

OK

CANCEL

7606

## FIG. 77

7706 7701 7702 7705 7703

7710

INPUT OF COMPOSITION DATA		OPTION(Q)		FILE NAME		REVISION NUMBER		G	
FILE(E) EDITED TOOL(I)		COMPOSITION DATA		COMPOSITION NAME		COMPOSITION NAME		COMPOSITION NAME	
TARGET MODEL		PER1000		COMPOSITION NAME		COMPOSITION NAME		COMPOSITION NAME	
G.NO.		WORK NAME		MA-PROVISIONAL		MA-PROVISIONAL		MA-PROVISIONAL	
UNIT NAME		UNIT NAME		UNIT NAME		UNIT NAME		UNIT NAME	
1		1		1		1		1	
2		2		2		2		2	
3		3		3		3		3	
4		4		4		4		4	
5		5		5		5		5	
6		6		6		6		6	
7		7		7		7		7	
8		8		8		8		8	
9		9		9		9		9	
10		10		10		10		10	
11		11		11		11		11	
12		12		12		12		12	
13		13		13		13		13	
14		14		14		14		14	
15		15		15		15		15	
16		16		16		16		16	
17		17		17		17		17	
18		18		18		18		18	
19		19		19		19		19	
20		20		20		20		20	
21		21		21		21		21	
22		22		22		22		22	
23		23		23		23		23	
24		24		24		24		24	
25		25		25		25		25	
26		26		26		26		26	
27		27		27		27		27	
28		28		28		28		28	
29		29		29		29		29	
30		30		30		30		30	
31		31		31		31		31	
32		32		32		32		32	
33		33		33		33		33	
34		34		34		34		34	
35		35		35		35		35	
36		36		36		36		36	
37		37		37		37		37	
38		38		38		38		38	
39		39		39		39		39	
40		40		40		40		40	
41		41		41		41		41	
42		42		42		42		42	
43		43		43		43		43	
44		44		44		44		44	
45		45		45		45		45	
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47		47		47		47		47	
48		48		48		48		48	
49		49		49		49		49	
50		50		50		50		50	
51		51		51		51		51	
52		52		52		52		52	
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58		58		58		58		58	
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62		62		62		62		62	
63		63		63		63		63	
64		64		64		64		64	
65		65		65		65		65	
66		66		66		66		66	
67		67		67		67		67	
68		68		68		68		68	
69		69		69		69		69	
70		70		70		70		70	
71		71		71		71		71	
72		72		72		72		72	
73		73		73		73		73	
74		74		74		74		74	
75		75		75		75		75	
76		76		76		76		76	
77		77		77		77		77	
78		78		78		78		78	
79		79		79		79		79	
80		80		80		80		80	
81		81		81		81		81	
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83		83		83		83		83	
84		84		84		84		84	
85		85		85		85		85	
86		86		86		86		86	
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88		88		88		88		88	
89		89		89		89		89	
90		90		90		90		90	
91		91		91		91		91	
92		92		92		92		92	
93		93		93		93		93	
94		94		94		94		94	
95		95		95		95		95	
96		96		96		96		96	
97		97		97		97		97	
98		98		98		98		98	
99		99		99		99		99	
100		100		100		100		100	
101		101		101		101		101	
102		102		102		102		102	
103		103		103		103		103	
104		104		104		104		104	
105		105		105		105		105	
106		106		106		106		106	
107		107		107		107		107	
108		108		108		108		108	
109		109		109		109		109	
110		110		110		110		110	
111		111		111		111		111	
112		112		112		112		112	
113		113		113		113		113	
114		114		114		114		114	
115		115		115		115		115	
116		116		116		116		116	
117		117		117		117		117	
118		118		118		118		118	
119		119		119		119		119	
120		120		120		120		120	
121		121		121		121		121	
122		122		122		122		122	
123		123		123		123		123	
124		124		124		124		124	
125		125		125		125		125	
126		126		126		126		126	
127		127		127		127		127	
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129		129		129		129		129	
130		130		130		130		130	
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132		132		132		132		132	
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134		134		134		134		134	
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136		136		136		136		136	
137		137		137		137		137	
138		138		138		138		138	
139		139		139		139		139	
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142		142		142		142		142	
143		143		143		143		143	
144		144		144		144		144	
145		145		145		145		145	
146		146		146		146		146	
147		147		147		147		147	
148		148		148		148		148	
149		149		149		149		149	
150		150		150		150		150	
151		151		151		151		151	
152		152		152		152		152	
153		153		153		153		153	
154		154		154		154		154	
155		155		155		155		155	
156		156		156		156		156	
157		157		157		157		157	
158		158		158		158		158	
159		159		159		159		159	
160		160		160		160		160	
161		161		161		161		161	
162		162		162		162		162	
163		163		163		163		163	
164		164		164		164		164	
165		165		165		165		165	
166		166		166		166		166	
167		167		167		167		167	
168		168		168		168		168	
169		169		169		169		169	
170		170		170		170		170	
171		171		171		171		171	
172		172		172		172		172	
173		173		173		173		173	
174		174		174		174		174	
175		175		175		175		175	
176		176		176		176		176	
177		177		177		177		177	
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179		179		179		179		179	
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181		181		181		181		181	
182		182		182		182		182	
183		183		183		183		183	
184		184		184		184		184	
185		185		185		185			

**FIG. 78**

09753726 "101301  
10610" 327676

INSERTION OF UNIT WORK

NEW WORK WILL BE INSERTED BEFORE  
"STICK CHECK SHEET SERIAL NO."

INPUT WORK NAME AND PROVISIONAL MANHOUR VALUE

UNIT WORK NAME :

7801

PROVISIONAL MANHOUR :  (RU)

7802

REMARKS :

OK

CANCEL

FIG. 79

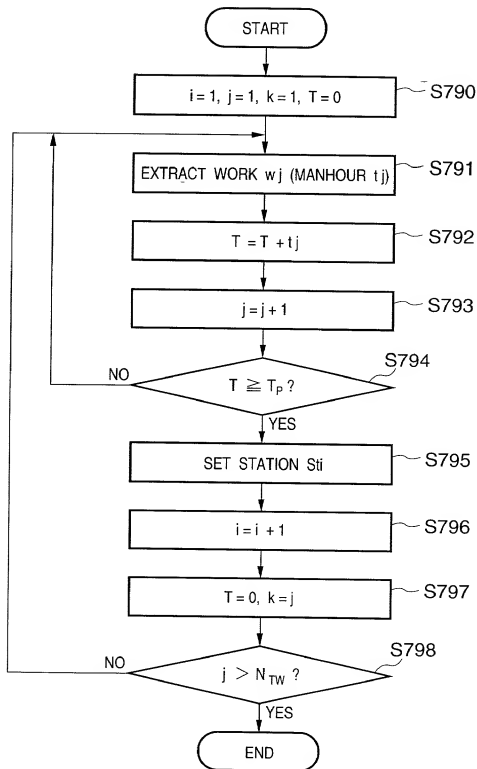


FIG. 80

FILE(E) EDIT(E) VIEW(D) TOOL(T)

8001 OPERATOR 1

8002 OPERATOR 2

8003 OPERATOR 3

8004 OPERATOR 4

8005 OPERATOR 5

8006

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8009

8010

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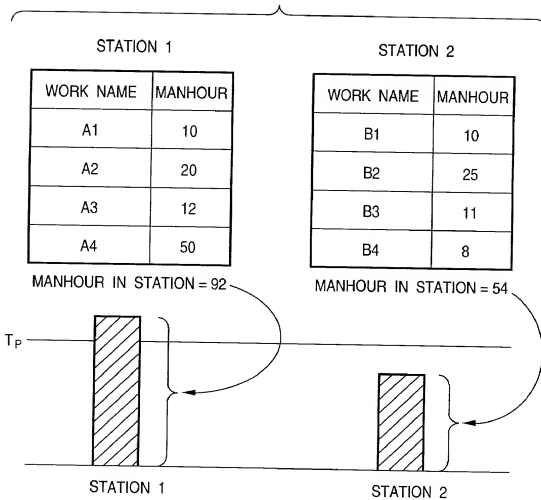
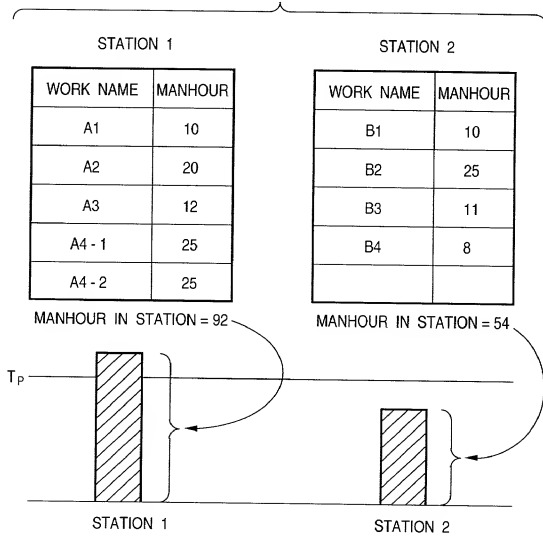
**FIG. 81**

FIG. 82



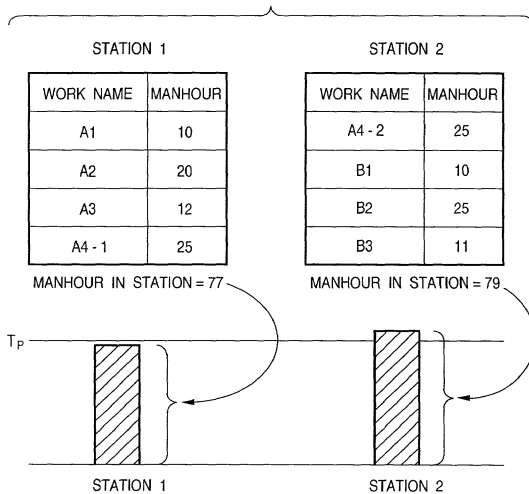
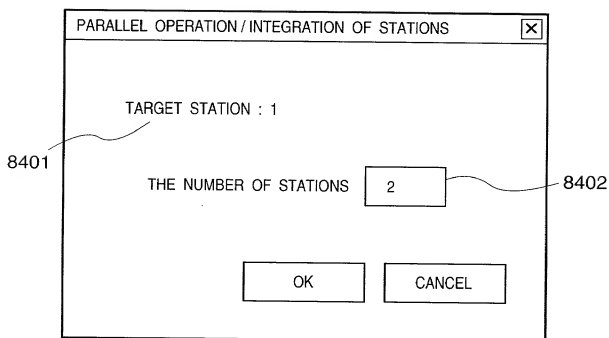
**FIG. 83**

FIG. 84





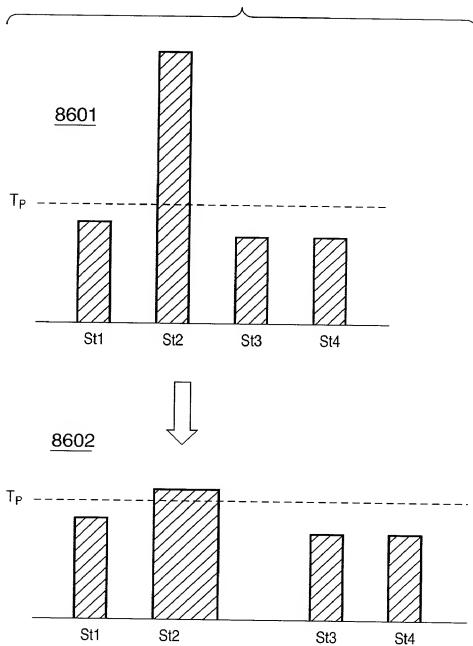
**FIG. 86**

FIG. 87

09753726-101901

The figure shows a 'USER REGISTRATION' dialog box with a close button (X) in the top right corner. It contains five input fields and two buttons. The fields are labeled on the left and have corresponding reference numbers on the right: 'NAME CODE' (8701) with value '12345', 'NAME' (8702) with values 'TANAKA' and 'ICHIRO', 'POSITION' (8703) with value 'kumitate' and a dropdown arrow, 'PASSWORD' (8704) with value '12345', and 'AUTHORITY' (8705) which is empty. At the bottom are 'OK' and 'CANCEL' buttons.

Field Label	Value	Reference Number
NAME CODE :	12345	8701
NAME :	TANAKA ICHIRO	8702
POSITION :	kumitate	8703
PASSWORD :	12345	8704
AUTHORITY :		8705

OK CANCEL

FIG. 88

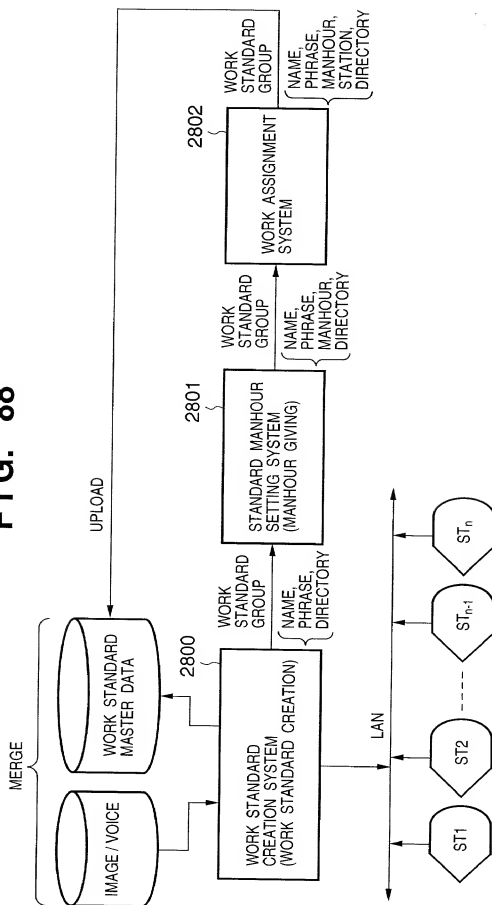


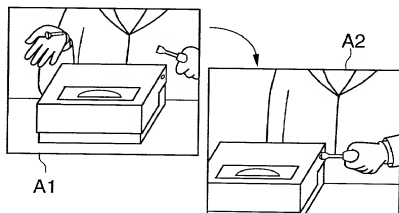


FIG. 89

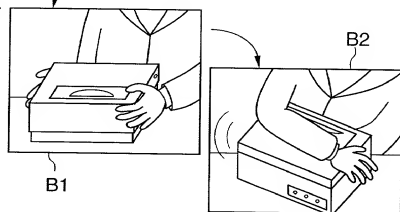
DIRECTORY NAME	IMAGE DATA	OPERATION (VERB)	PARAMETER 1	PARAMETER 2	PARAMETER 3
xxxxx1	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 10mm	TORQUE 10Kg.M
xxxxxx2	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 20Kg.M
xxxxxx3	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 30Kg.M
...	...	...	...	...	...
yyyyyy1	ROTATE	ROTATE	CLOCKWISE	DISTANCE MOVEMENT 20mm	
yyyyyy2	ROTATE	ROTATE	COUNTERCLOCKWISE	DISTANCE MOVEMENT 20mm	
...	...	...	...	...	...
zzzzzz1	OPEN	OPEN	OPEN UPWARD	DISTANCE MOVEMENT 30mm	WEIGHT 100g
zzzzzz2	OPEN	OPEN	OPEN DOWNWARD	DISTANCE MOVEMENT 40mm	WEIGHT 200g
...	...	...	...	...	...

FIG. 90

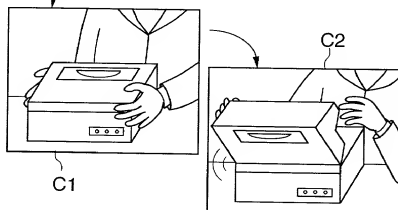
## 1. SCREW A



## 2. ROTATE MAIN BODY



## 3. OPEN COVER



**FIG. 91**

9101 9102

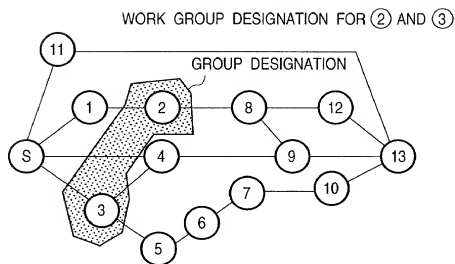
SETTING OF COMPONENT SYMBOL

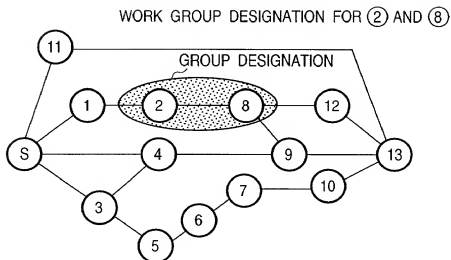
PRODUCT SYMBOL : BJ - 970909

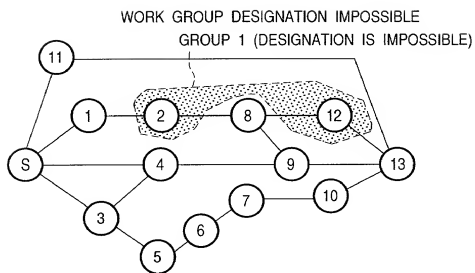
COMPONENT SYMBOL : CH

COMPONENT NAME : CHECK

OK SEARCH COMPONENT CANCEL

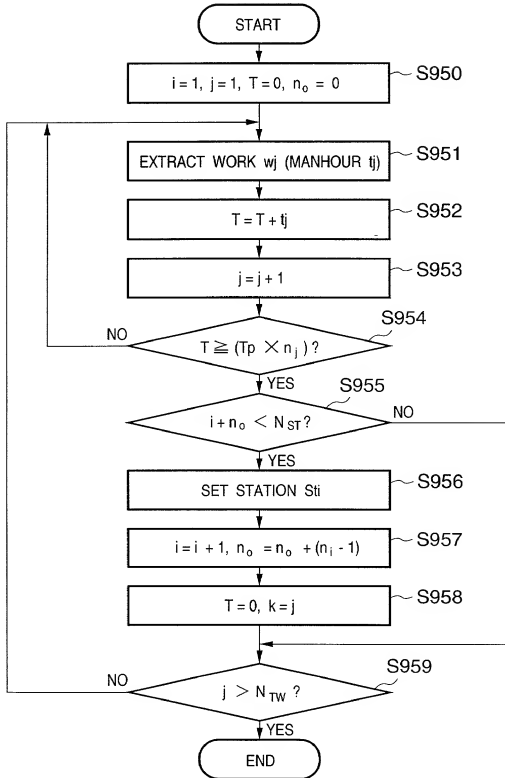
**FIG. 92**

**FIG. 93**

**FIG. 94**

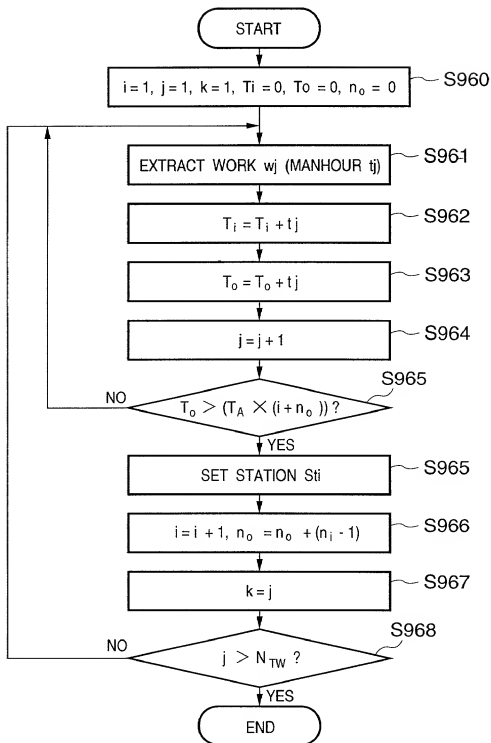
95/97

**FIG. 95**



$N_{ST}$  : THE NUMBER OF STATIONS  
 $n_i$  :  $i$  STATION PARALLEL NUMBER  
 $n_0$  : TOTAL ACCUMULATED PARALLEL SUM NUMBER

69753726-104904



$N_{ST}$  : THE NUMBER OF STATIONS  
 $T_i$  :  $i$  STATION MANHOUR  
 $TA$  : STATION MANHOUR AVERAGE VALUE  
 $T_A = WF / N_{ST}$   
 $T_o$  : TOTAL ACCUMULATED MANHOUR  
 $n_i$  :  $i$  STATION PARALLEL NUMBER  
 $n_o$  : TOTAL ACCUMULATED PARALLEL  
 SUM NUMBER



**FIG. 97**

FILE(E) EDIT(E) VIEW(D) TOOL(I)

OPERATOR 1

WORK NAME

WF

PROV. SOCIAL MAN/POUR

MA- CHINE UAL

OPERATOR 2

WORK NAME

WF

PROV. SOCIAL MAN/POUR

MA- CHINE UAL

OPERATOR 3

WORK NAME

WF

PROV. SOCIAL MAN/POUR

MA- CHINE UAL

OPERATOR 4

WORK NAME

WF

PROV. SOCIAL MAN/POUR

MA- CHINE UAL

OPERATOR 5

WORK NAME

WF

PROV. SOCIAL MAN/POUR

MA- CHINE UAL

OPERATOR 6

WORK NAME

WF

PROV. SOCIAL MAN/POUR

MA- CHINE UAL

START

0

0

No

UNIT WORK

34

10

No 07

NAME 1

25

46

No 02

NAME 2

92

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NAME 3

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NAME 4

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No 06

NAME 5

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NAME 6

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